

Work Order ID 53140

October 23, 2009 8:41:31 AM



Page 1

Item ID: D407-667-205

Accept



Setup Start



Revision ID: F

Stop



Item Name: Crosstube Aft

Start Date: 23/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *PL*

Date: *07-10-23*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D407-667-245

Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D407-667-205 CHG006

Sorkul

HJ for BG 09/11/25

110

0.00



Packaging

Packaging

Memo

0.00

Packaging

MB 09-11-11

120

0.00



BENDING MACHINE - CROSSTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend tube as per Dwg D407-667-245 using CNC bender program 407 Aft and Folio FT

DP

9-11-11

October 23, 2009 8:41:31 AM

Page 2



Accept

**Setup Start**

F

Stop



Crosstube Aft

Start Qty: 1.00

**Cust Item ID:**

Req'd Qty: 1.00



Customer:

Reference:

Run Start



Stop



Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

OC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

Work Order ID 53140

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Item ID: D407-667-205

Accept



Setup Start



Revision ID: F

Stop



Item Name: Crosstube Aft

Start Date: 23/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

190

0.00



Packaging

Packaging

Memo

0.00

Packaging

Ensure copy of NDT results attached to work order.

Signature 09/11/12

200

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Signature 09 11 19 (1)

210

0.00



SprayPaint

SprayPaint

Memo

0.00

Spray Painting

1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube with White Imron as per QSI 005 4.2
Time: 4:30 □ Finish Time: 10:30 PAINT: □ Start
Time: 3:30 □ Finish Time: 4:30

Signature 09 11 19 (1)

Work Order ID 53140

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Item ID: D407-667-205

Accept



Setup Start



Revision ID: F

Stop



Item Name: Crosstube Aft

Start Date: 23/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/11/25 *[Signature]*

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

2) 8 02/4/25

[Signature]

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and in kanban rack ☐ Location: _____

Nov 2

[Signature] 9/14/20

Work Order ID 53140

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Item ID: D407-667-205

Accept



Setup Start



Revision ID: F

Stop



Item Name: Crosstube Aft

Start Date: 23/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/25 J

R 09-11-25

Picklist Print

October 23, 2009 8:41:37 AM

Page 1

Work Order ID: 53140

Parent Item: D407-667-205RevF

Parent Item Name: Crosstube Aft

Comments:

Start Date: 23/10/2009

Required Date: 13/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN960JD516

Purchased

No

100

Each

1,595.000

18.0000

Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1595

100564

2

106167

6

107534

34

107959

43

108246

46

108672

2

109059

49

109752

22

110363

46

110523

57

111279

39

112082

68

112314

500

112794

181

112828

500

D2856-400RevA

Manufactured

No

230

f

169.7337

1.3558

Abraison Strip

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST403

169.7336842

50593

169.733684

ml 09.11.24

Picklist Print

Page 2

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Work Order ID: 53140

Parent Item: D407-667-205RevF

Parent Item Name: Crosstube Aft

Comments:

Start Date: 23/10/2009

Required Date: 13/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2873-043RevA
Nut Plate Assembly

Manufactured No

230

Each

41.0000

2.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

41

45370

6

45422

15

50002

20

D2873-045RevA
Nut Plate Assembly

Manufactured No

230

Each

59.0000

2.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

59

45210

3

46772

16

50001

40

M 09 11 24

M 09 11 24

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Shop Packet Print

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Picklist Print

Page 3

October 23, 2009 8:41:37 AM

Work Order ID: 53140

Parent Item: D407-667-205RevF

Parent Item Name: Crosstube Aft

Comments:


Start Date: 23/10/2009

Required Date: 13/11/2009

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2894-1RevD		Manufactured	No			230	Each	29.0000	1.0000			
												
2.750 Support												

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	29	
	43713	10	
	43881	18	
	45483	1	

ml 09 11 23

D3190-1RevA		Manufactured	No			230	Each	30.0000	2.0000			
												
Chafing Shield												

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	30	
	40109	10	
	47456	20	

ml 09 11 24

D407-667-205TRNRevF		Manufactured	No			230	Each	2.0000	1.0000			
												
Crosstube Turning Detail												

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	FG	2	
	48432	1	
	48433	1	

(1X) ml 09-11-11

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Shop Packet Print

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Picklist Print

Page 4

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Work Order ID: 53140



Parent Item: D407-667-205RevF



Parent Item Name: Crosstube Aft

Start Date: 23/10/2009

Required Date: 13/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
-----------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS20601-AD4W8

Purchased

No

230

Each

300.0000

14.0000



RIVET

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

110399

ST

300

~~108521~~

100

~~112203~~

200

MS21920-22

Purchased

No

230

Each

98.0000

4.0000



Clamp(per MIL-DTL-8783C)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

98

109495

6

110260

42

111210

50

ml 02 11 24

ml 02 11 24

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Picklist Print

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Work Order ID: 53140

Parent Item: D407-667-205RevF

Parent Item Name: Crosstube Aft

Comments:


Start Date: 23/10/2009

Required Date: 13/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Port Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

8 AN5-10A  Bolt		Purchased	No			260	Each	153.0000	10.0000		9/11/25	sl
--	--	-----------	----	--	--	-----	------	----------	---------	--	---------	----

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	153	
107013	8	
110363	2	
112314	26	
112385	50	
112805	17	
112933	50	

8 AN5-32A  Bolt		Purchased	No			260	Each	147.0000	4.0000		9/11/25	sl
--	--	-----------	----	--	--	-----	------	----------	--------	--	---------	----

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	147	
106242	3	
106519	4	
110363	17	
112082	23	
112805	50	
112933	50	

Picklist Print

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Work Order ID: 53140

Parent Item: D407-667-205RevF

Parent Item Name: Crosstube Aft


Comments:

Start Date: 23/10/2009

Required Date: 13/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN5-34A  Bolt		Purchased	No			260	Each	34.0000	4.0000		9/11/25	SD

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	34	
104679	2	
105408	1	
107013	2	
111425	29	

MS21042L5



Nut

Purchased

No

260

Each

1,077.000 4.0000



9/11/25 RDSY

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1077	
110382	10	
111127	4	
111636	63	
112314	1000	

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Picklist Print

Page 7

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Work Order ID: 53140



Parent Item: D407-667-205RevF



Parent Item Name: Crosstube Aft

Start Date: 23/10/2009

Required Date: 13/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21920-25		Purchased	No			260	Each	168.0000	2.0000			

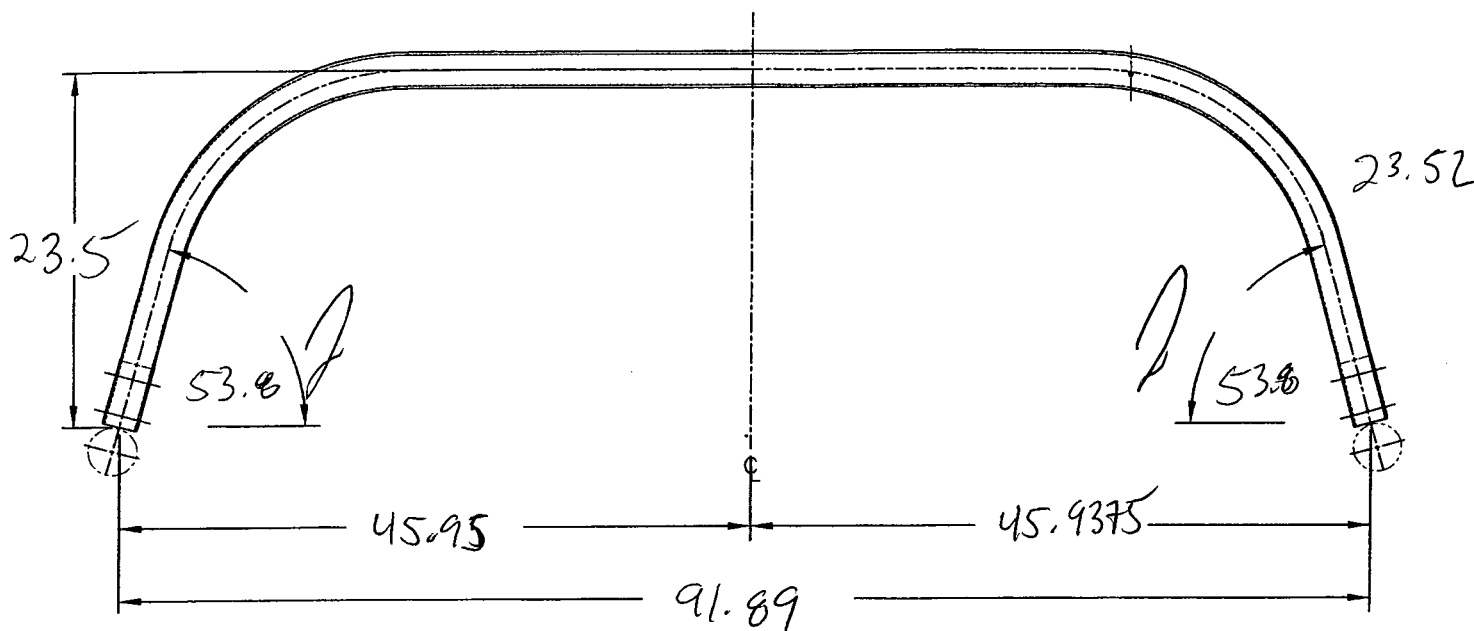
Clamp(per MIL-DTL-8783C)

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	168	
107456	2	
108111	3	
108975	17	
109181	48	
109644	10	
111282	4	
111429	9	
<u>112495</u>	50	
112919	25	

m/ 09.11.24

DART AEROSPACE LTD	Work Order: B-53140	
Description: Crosstube High Aft (407)	Part Number: D407-667-205	
Inspection Dwg: D407-667-245 Rev: F		Page 1 of 1

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	45.86	45.98
Angle	54	56
Total Span	91.72	91.96



Comments

QC15 Inspection	<i>[Signature]</i>
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	09.06.22	Dwg Rev updated	KJ	

Item	QTY -245	PART NUMBER	DESCRIPTION
1	X	D407-667-245	CROSSTUBE ASSEMBLY (407 HIGH AFT)
2	1	D6011-115	CROSSTUBE
3	2	D2856-400-773	ABRASION STRIP
4	2	D2873-043	NUT PLATE
5	2	D2873-045	NUT PLATE
6	1	D2894-1	SUPPORT
7	2	D3190-1	CHAFING SHIELD
8	2	D3595-063-430	RUBBER CUSHION
9	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
10	4	MS21920-22	CLAMP
11	2	MS21920-25	CLAMP (OR MS21920-24)
12	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947- 100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

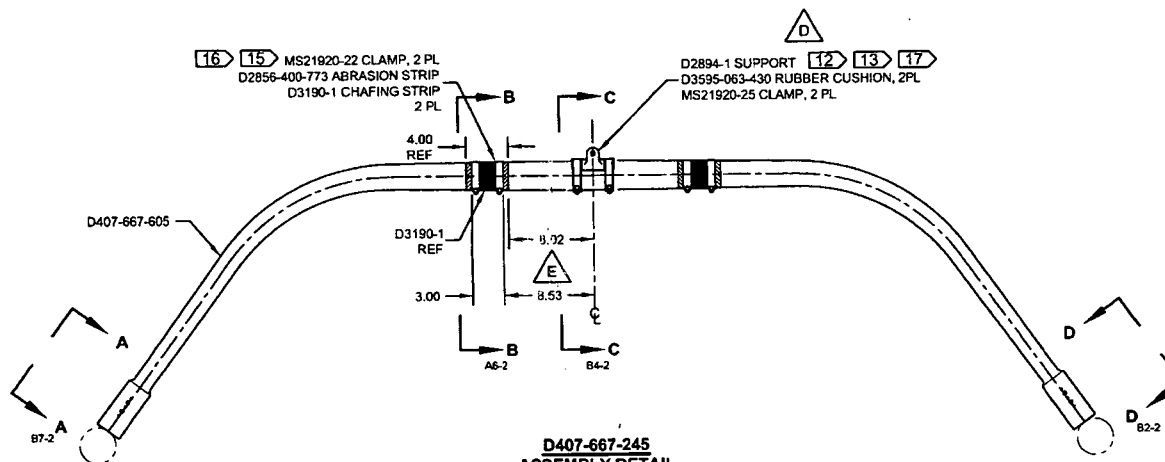
- 1) MATERIAL: MANUFACTURED FROM D6011-115
FINISHED LENGTH = 112.91±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D407-667-245" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 27.7 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2894-1 CENTER SUPPORT USING A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-25 CLAMPS WITH D3595-063-430 RUBBER CUSHIONS TO SECURE D2894-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
NOTE: MS21920-24 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, PER QSI 035.
- 16) INSTALL D3190-1 CHAFING SHIELDS SO THAT OVERLAP IS ON BOTTOM SIDE OF CROSSTUBE OPPOSITE D2894-1 SUPPORT.
- 17) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
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WITHOUT NOTICE
WORK ORDER

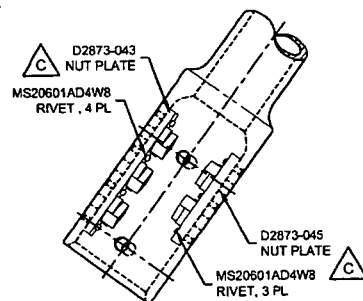
NO. 53146
RD 09-10-23

RELEASED
08/11/23

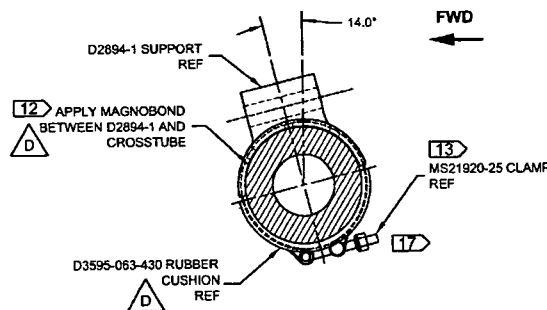
F	REFORMAT NOTES TO NEW STANDARDS (ZN B8-1); RELOCATED FLAG # 6 (ZN A8-3) PER NCR 210; REMOVED REF. & ADD TOLERANCES (ZN C6-3, C4-3 & D2-3)	RF	08.11.06
E	8.02 AND 8.53 WERE 8.40 AND 8.90 (ZN D5-2); REORGANIZED VIEWS AND REFORMATED DRAWING TO CURRENT STANDARDS. REASONS: CLAMPS MOVED 0.375 TOWARD CL TO ELIMINATE INTERFERENCE WITH AIRCRAFT MOUNTS. REFERENCE: PAR#08-21 AND ECN#1225	MB	08.07.24
D	ADD VIEW FOR OEM SKID HOLES. ROTATE ORIENTATION OF CLAMPS SECTION F-F. REMOVE -851 ABRASION STRIP. ADD MAGNOBOND 6398. ADD CUSHION	PH	07.02.07
C	ADD HOLES AND NUT PLATES FOR COMPATIBILITY WITH BHT/AA SKIDTUBES	PH	05.07.26
B	ADD CHAFING SHIELD	CP	03.05.21
A	NEW ISSUE	CP	02.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. F
CHECKED	RF	D407-667-245	SHEET 1 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSSTUBE ASSY (407 HIGH AFT)	NTS
DE APPR.	RF	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.11.06		



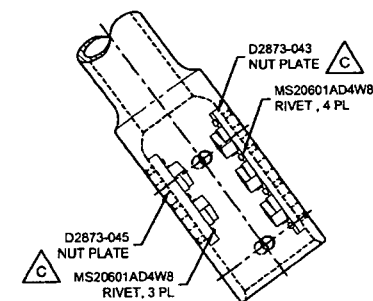
**D407-667-245
ASSEMBLY DETAIL
(VIEW LOOKING FWD)**



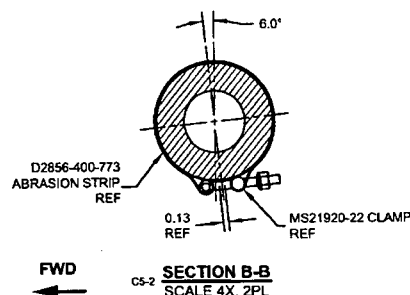
**VIEW A-A CUFF DETAIL
SCALE 4X**



**SECTION C-C
SCALE 4X**



**VIEW D-D CUFF DETAIL
SCALE 4X**



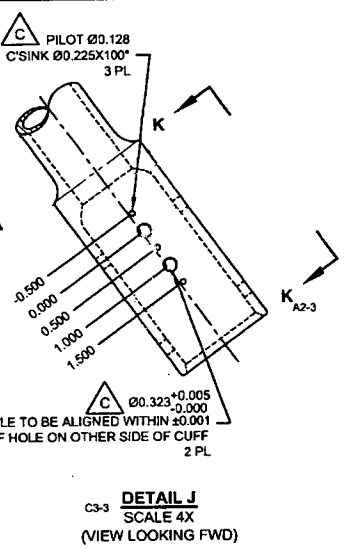
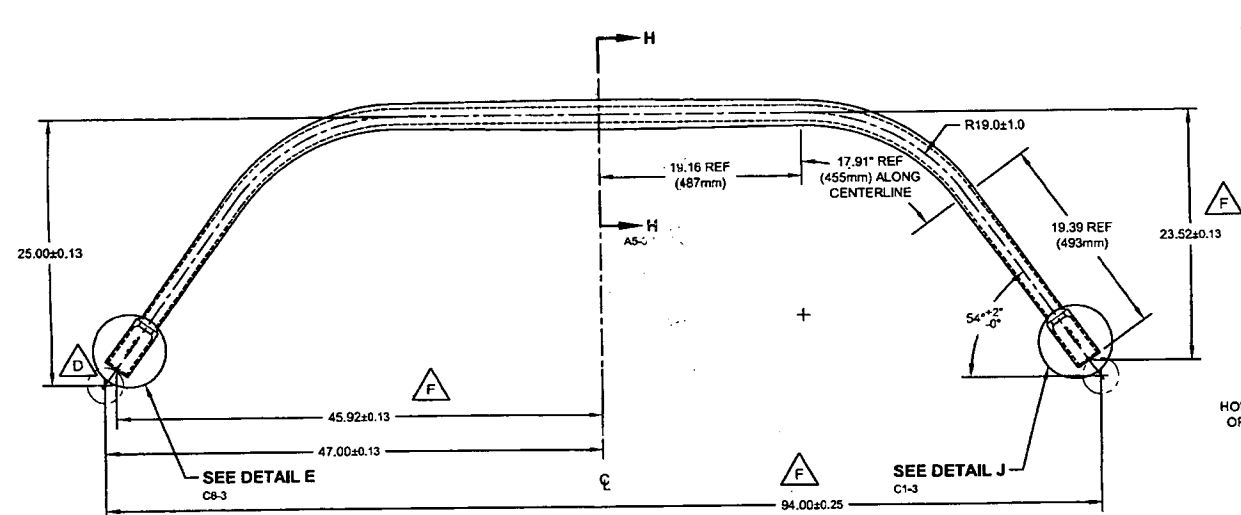
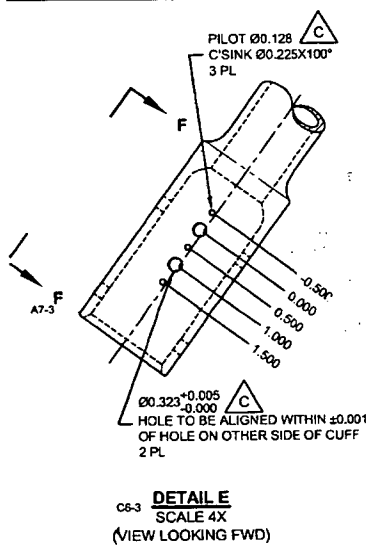
**SECTION B-B
SCALE 4X, 2PL**

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WORK ORDER
NO. 53140

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08/11/06

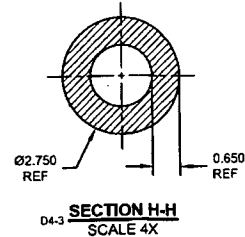
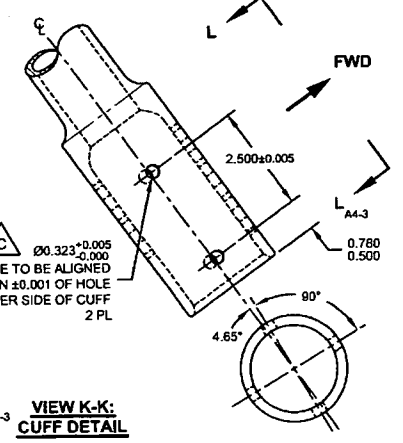
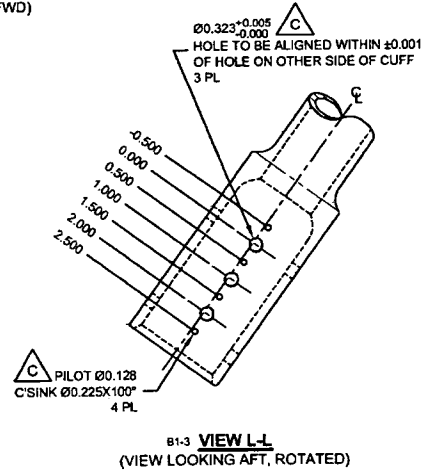
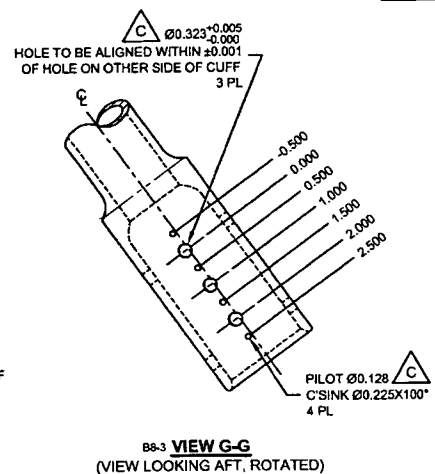
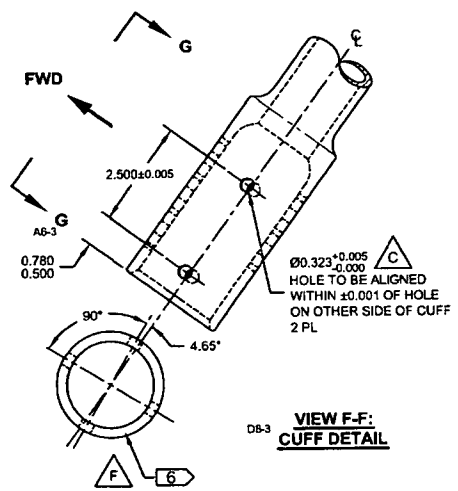
DESIGN	90	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. F
MFG. APPR.	EP	D407-667-245	SHEET 2 OF 4
APPROVED	EP	TITLE	SCALE
DE APPR.	EP	CROSSTUBE ASS'Y (407 HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1



D407-667-605
BENDING AND DRILLING DETAIL
(VIEW LOOKING FWD)

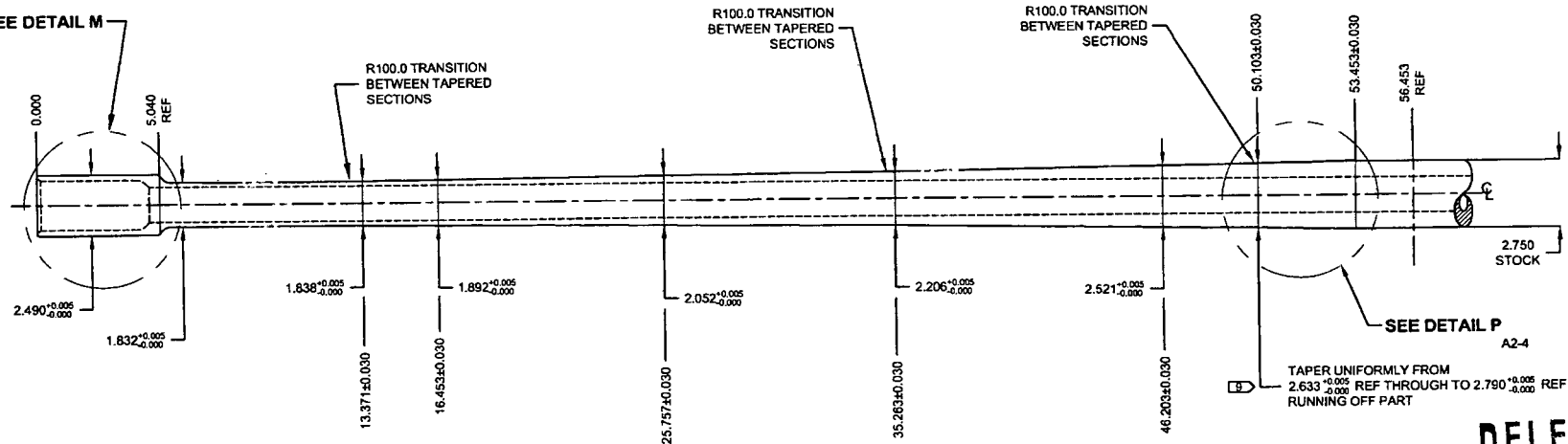
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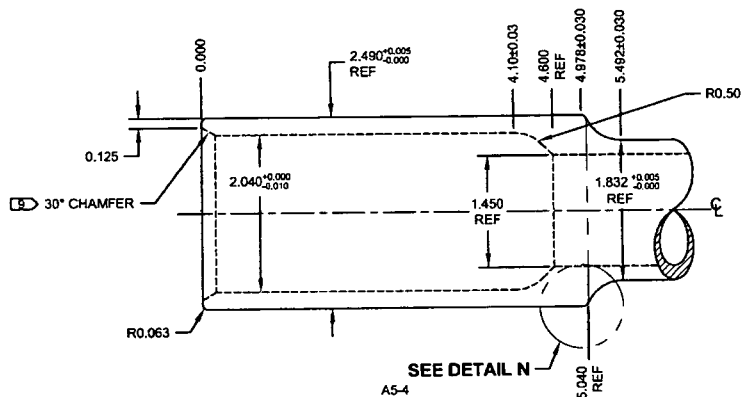
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WORK ORDER
NO. 53140

DESIGN	00	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	EP	DRAWING NO. D407-667-245	REV. F
MFG. APPR.	EP		SHEET 3 OF 4
APPROVED	EP	TITLE	SCALE
DE APPR.	EP	CROSSTUBE ASS'Y (407 HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

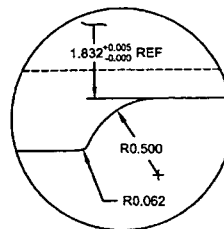
SEE DETAIL M
A7-4



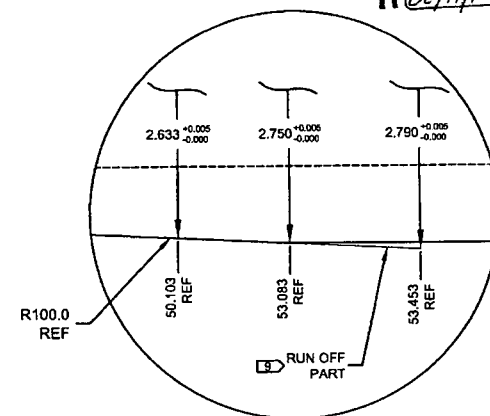
D407-667-245 MACHINING DETAIL



DETAIL M: CROSSTUBE CUFF
SCALE 3X



DETAIL N: CUFF TRANSITION
SCALE 2X



DETAIL P: TAPER RUN-OFF
NOT TO SCALE

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DESIGN	0	DART AEROSPACE LTD	
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MFG. APPR.	0	D407-667-245	SHEET 4 OF 4
APPROVED	0	TITLE	SCALE
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LIQUID PENETRANT TEST REPORT

P- 15308

CLIENT DART AEROSPACE DATE NOVEMBER 12 PAGE 1 OF 1
ATTENTION LINDA/CHANTEL TIME AM ☒ PM ☐
ADDRESS 1270 ABELDEEN ST. ACUREN JOB NO. 188-09-2008
HAWKES BURY, ON. POWO No. 10748
KGH IK7 WORK LOCATION SAME AS NOTED.
PROJECT F.P.I. ON CROSS TUBES. ACCEPTANCE STD. ASTM 1417 REV./DATE 2007
ITEM(S) EXAMINED FIVE ITEMS

JOB DESCRIPTION PROCEDURE NO. LT-2002 REV./DATE TECHNIQUE NO. LT-TECH 2 REV./DATE
PART NO. — MATERIAL ALUMINE ALUMINUM THICKNESS N/A
SCOPE WET FLUORESCENT LIQUID PENETRANT INSPECTION
CARRIED OUT 100% EXTERNAL

TEST DETAILS
METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND MAGNAFLUX BLACK LIGHT S/N 16459 ☒ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
PENETRANT 2L 67 MINIMUM DWELL TIME 45 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER 120 MINIMUM DRY TIME >10 MIN. OTHER LABINO
DEVELOPER SKD 52 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N CAL DUE DATE DEC. 8, 2007
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE
SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☒ MACHINED ☐ SHOT BLASTED ☐ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/50°F ☒ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)

1 CROSS TUBE - W.O. 53139 ✓
1 CROSS TUBE - W.O. 53140 ✓
1 CROSS TUBE - W.O. 53271 ✓
1 CROSS TUBE - W.O. 53272 ✓
1 CROSS TUBE - W.O. 52050 ✓

not 05 11 19

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE MATT MURDOCH DTR # E-27851
TECHNICIAN (SIGNATURE): [Signature] SIGNATURE
NAME (PRINT): Mike Johnston REPORT REVIEWED BY:
1ST TECHNICIAN 2ND TECHNICIAN
CGSB LEVEL I SNT LEVEL II CGSB LEVEL — SNT LEVEL —
CGSB REG. NO. 6066 CGSB REG. NO. —

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